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DATE 00.10.23		TITLE LANDING LIGHT MODIFICATION	SCALE NTS
A	00.10.23	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. C  
REF. CANADIAN STC: SH92-18 & FAA STC: SH989NE / SH990NE  
FOR

### **LANDING LIGHT MODIFICATION**

PRIOR TO INSTALLING THE DART D350-567-021 LARGE FLOOR WINDOW INSTALLATION ON AIRCRAFT EQUIPPED WITH 355A64-7047-38 (OR EQUIVALENT) LANDING LIGHT, PERFORM THE FOLLOWING MODIFICATION:

- (1) Remove the 355A64-7047-38 Landing Light and 350A21-0025-02 (or equivalent) Fairing.
- (2) Attach a backing plate with release film to outside surface of fairing to match fairing curvature. An aluminum sheet and release film taped on with Teflon tape is recommended.
- (3) For fiberglass modifications in these instructions use the following materials:
  - (i) 9 oz cloth: 9.7 oz. 7781 "S" Glass Universal Weave, OR equivalent.
  - (ii) Adhesive/Resin: EPOCAST 50-A/9816 (CIBA GEIGY), OR equivalent.
  - (iii) Adhesive paste: Mixture of adhesive, Milled Fibers E-Glass (CIBA GEIGY), and K20 Glass Bubbles (3M), OR 5 minute epoxy, OR equivalent.
- (4) Fill holes shown in Figure 1 with adhesive paste.
- (5) Lay up 1 layer of 9 oz. cloth on inside surface of fairing, covering part of the cutout and surrounding area shown in Figure 1. Cut and lay up 2 layers of 9 oz. cloth inside the cutout to match the contour in the fairing. Lay up 2 layers of 9 oz cloth to form new inside skin, staggering the size of each cloth, with the final piece covering an area 2" around the cutout. The cutout should be filled to 9.5" from fairing edge (see Figure 1). Cure at room temperature for 24 hours.
- (6) Remove the backing plate. Lay up 1 layer of 9 oz. cloth covering and surrounding the newly filled cutout to create a new outside skin. An area 2" around filled cutout should be covered as shown in Figure 1. Cure at room temperature for 24 hours.
- (7) Position the Landing Light one hole length aft of its original position (approximately 3" aft). Mark the location of the Landing Light's attachment holes using the Landing Light casing as a guide. Remove the casing and drill holes  $\varnothing 0.250$  (12 places). Trim fiberglass 1.00" from edge of Landing Light casing, as shown in Figure 2. Trim the forward edge of the cutout only.
- (8) For the hole going through the foam core (1 place – see Detail C):
  - (i) Remove foam core within 0.5" radius of hole center.
  - (ii) Fill cavity with adhesive paste. Care shall be taken to avoid trapped air or incomplete fill within the potted area.
  - (iii) Cure at room temperature for 24 hours.
  - (iv) Re-drill  $\varnothing 0.250$  hole through panel.
- (9) For holes near the edge of the core (2 places), trim foam within 0.5" radius of hole center at a 45° angle and apply 2 layers of 9 oz cloth covering an area 2.0" around the holes as shown in Detail B. Cure at room temperature for 24 hours. Re-drill  $\varnothing 0.250$  hole through panel.
- (10) Trim Landing Light casing to match contour of jacking hole as required.
- (11) Touch up paint per the Aircraft Maintenance Manual to match original finish.
- (12) Install D350-567-021 per D350-567 Rev. C
- (13) Re-install Landing Light using existing hardware and qty (1) MS35207-284 screw, qty (1) AN960JD416 washer, and qty (1) MS21042L4 nut (see Detail C).

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FIGURE 1: FAIRING MODIFICATION

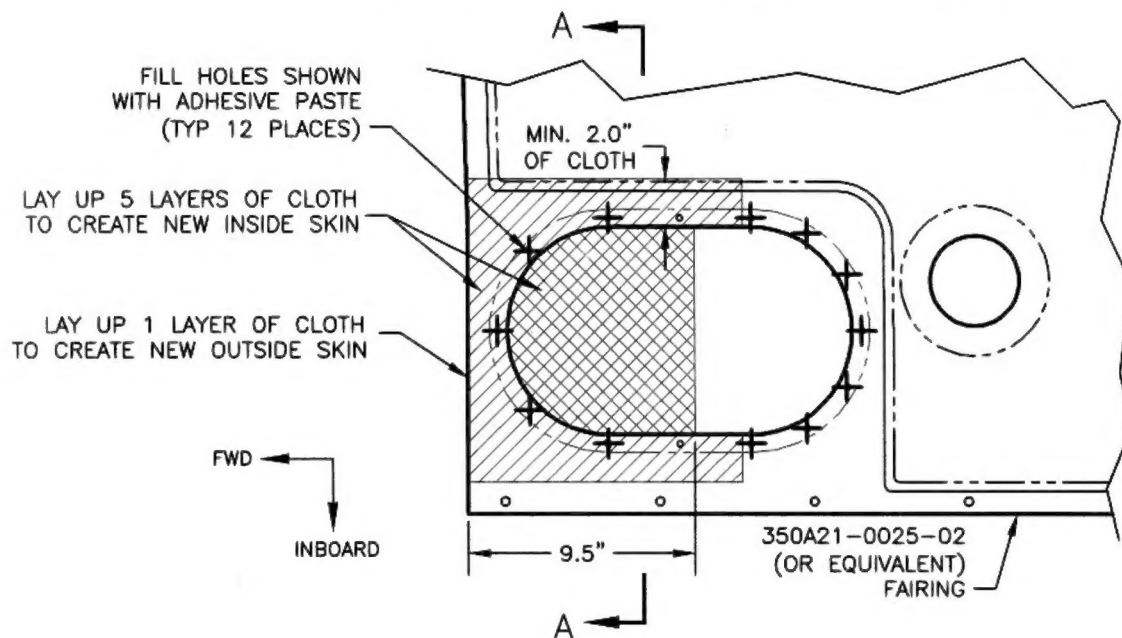
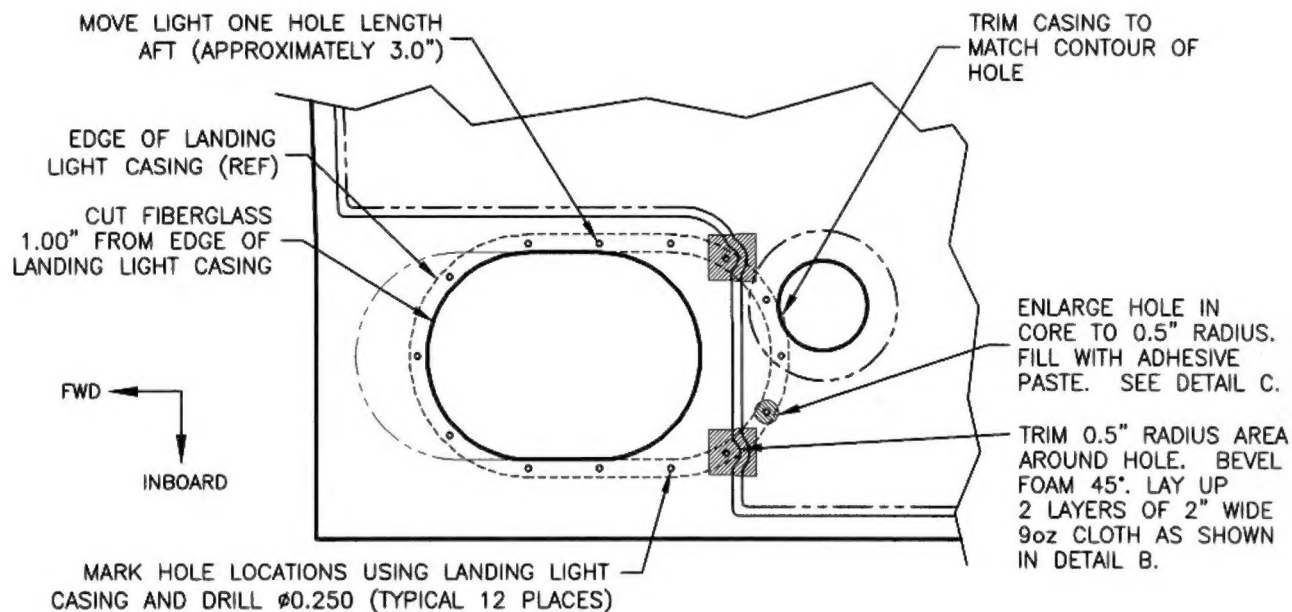


FIGURE 2: LANDING LIGHT RE-INSTALLATION

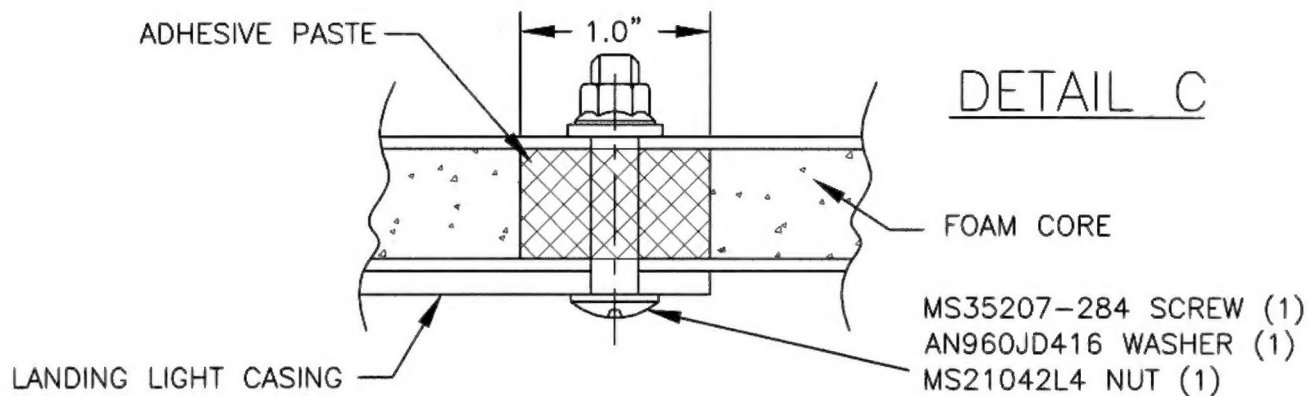
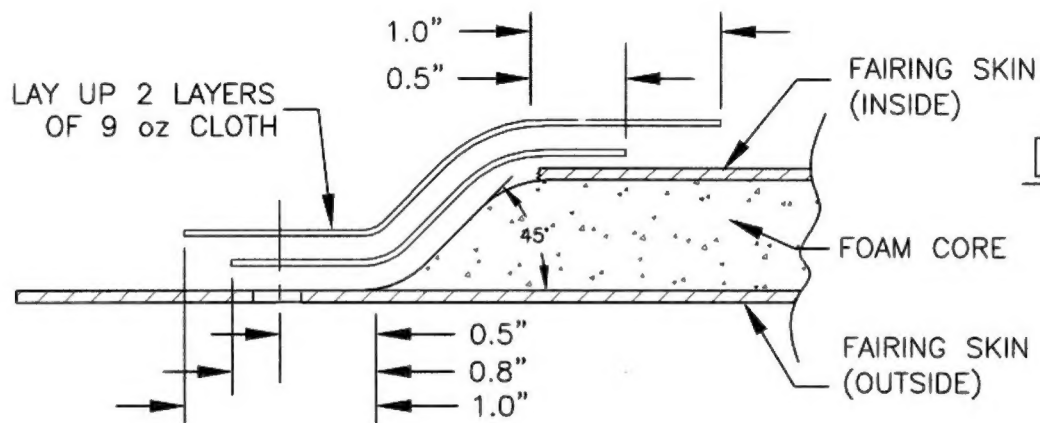
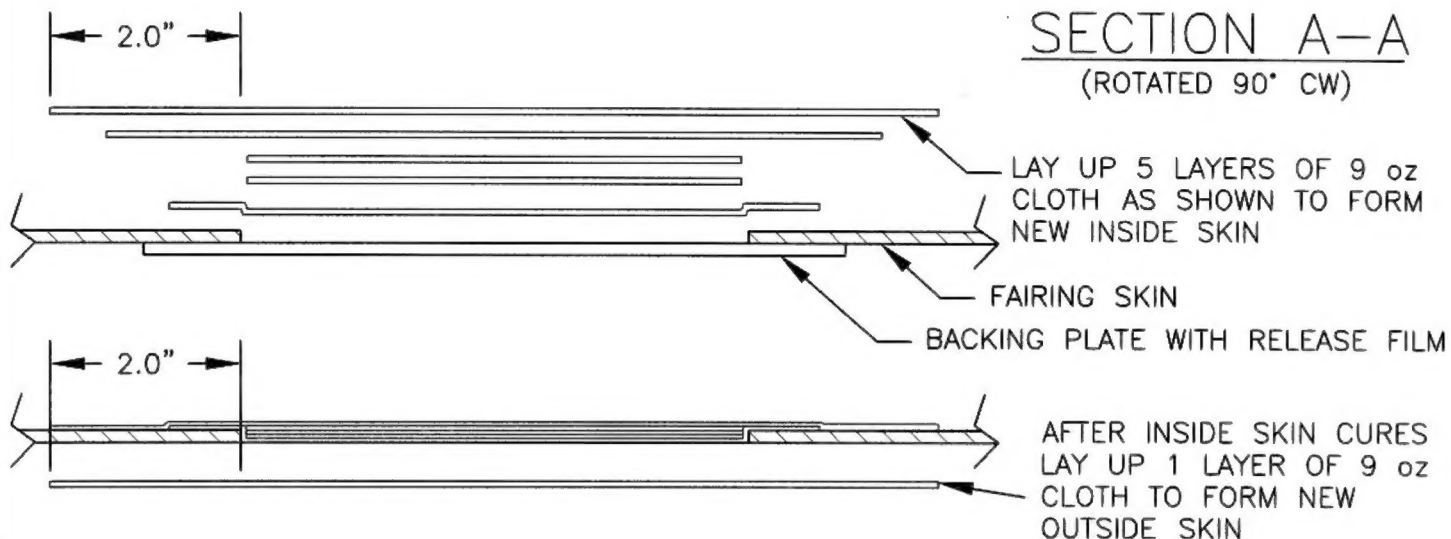


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